Work Order Thursday, December		•	75 k)								Page 1
Revision ID:	D3637-3 Bracket	(4)	V	Α	ccept					Setup Sta		
Start Date: 1 Required Date: 1 Reference:	2/16/2010 2/21/2010	Start Qty: 12.0 Req'd Qty: 12.0				Cust Item Customer:			÷			
	Process Plan	n:	Date://	124	Tooling: SPC (Y/N):		Pate:		I	Run Sta Sto		
Sequence ID/ Work Center ID	_	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D3637		ision Nbr									·	
100 Waterjet FLOW CNC Waterjet	Rev	FLOW WATER JET Memo 1-Cut as	per Dwg D3637 necessary	□Dwg Rev:	0.00 0.00 Prog Rev:_	₿ □2-	• .		1810	-17-10	<u>(8)</u>	
110 QC Quality Control		QC2- Inspect parts of	f machine FAI/F	AIB	0.00				<u> 18</u> (0	7-(3-	16	
120 QC Quality Control		QC8- Inspect parts - s	econd check		00.00	10)12/17			18			

Dart Aerospace L	_td
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W/O:			W	ORK ORDER CHANG	ES		· · · · · · · · · · · · · · · · · · ·				
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date Qt	Approval Y Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No	:	PAR #:	Fault Cat	egory:	_ NCR: Yes	No DQA:	Date: _				
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NCR:		,	WORK ORE	DER NON-CONFORM	ANCE (NCR)					
DATE	STEP	Description of NC			ion B	Verificatio		Approval			
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector			
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Page 2

Item ID:

D3637-3

Thursday, December 16, 2010 11:47:05 AM

Accept

Setup Start



Revision ID:

Item Name: Bracket

Start Date: 12/16/2010

Start Qty: 12.00

Required Date: 12/21/2010 Req'd Qty: 12.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop

Stop



QC:

Date:

SPC (Y/N):

Date:

Tool # Plan

Code

Accept Qty

Reject **Qty**

Reject Insp.

130

Sequence ID/

Work Center ID

Brake NC Brake NC

NC BRAKE

Operation

Description

Memo

Form as per Dwg D3637

0.00

Set Up/

Run Hours

So 10/12/17

Tool ID

Number Stamp

140

Quality Control

QC5- Inspect part completeness to step on W/O

(15112/12

(%) -

150

Small Fab

Small Fab

Memo

Memo

0.00

0.00

Small Fab

1- drill holes as per dwg using DT8979□2- c'sink holes as per dwg□3-deburr

=7m/l w/12

	22622								1
W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAI	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cate	jory:	_ NCR: Yes	No DQ	A:	Date: _	
Resolution:		esolution:	Disposition	1:	QA: N/C (Closed:		Date: _	
NCR:		-	WORK ORD	ER NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC	Initial		ion B Sign		ication	Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng	Date	Sec	tion C	Chief Eng	QC Inspector
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Work Orde												Page
Item ID: Revision ID: Item Name:	D3637-3 Bracket			Accept					Setup	Start Stop		
Start Date: Required Date: Reference:	12/16/2010 12/21/2010	Start Qty: 12.00 Req'd Qty: 12.00			Cust Item I Customer:	D:					11881181	
Approvals:	Process Pla	n:	Date:	Tooling:	Da	nte:	_		Run	Start		
	QC:		Date:	SPC (Y/N):	Da	ite:				Stop		
Sequence ID/ Work Center II 160)	Operation Description QC5- Inspect part comple	eteness to step on W/O	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp
[]]]]]]]]]]]]]]]]]]]]QC Quality Control		Мето		0.00 0 101	2/17	•		" And	<u>)</u>			
		Chemical Conversion Co	at per QSI005 4.1	0.00	H 10/12	120		v.1		a/		
HandFinish		Memo		0.00	אר ושוול	1 20		<u> X4</u>		/		

180

Quality Control

Hand Finishing

QC3- Inspect Part Finish

0.00

Memo

Memo

0.00

H BL 10-12-20.

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W/O:			WO	RK ORDER CH	ANGES					
DATE	STEP	PRO	OCEDURE CHAN	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	jory:	NC	R: Yes I	No DQ	A :	Date: _	
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NCR:		•	WORK ORDE	ER NON-CONFO	DRMANCI	E (NCR))			
DATE	OTED	Description of NC		Section B		Verifi	cation	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Descrip	ption 	Sign & Date	Sect	ion C	Chief Eng	QC Inspector

Work Order ID 64768

Required Date: 12/21/2010

Thursday, December 16, 2010 11:47:05 AM



Page 4

Item ID:

D3637-3

Accept

Setup Start

Revision ID:

Start Date:

Item Name:

Bracket

12/16/2010

Start Qty: 12.00

Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

SPC (Y/N):

Tool ID

Date:

Date:

Tool # Plan

Code

Stop



Sequence ID/ Work Center ID

190

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Date:

Set Up/ **Run Hours**

0.00

0.00

Run

Accept

Qty

Start



Reject Reject Insp. Qty Number Stamp

200

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

Memo

0.00

										ı
W/O:			W	ORK ORDER CHANG	ES	*				
DATE	STEP	PRO	OCEDURE CH	ANGE	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cat	tegory:	NCR: `	Yes N	o DQ/	\ :	Date:	
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DATE	STEP	Description of NC			tion B		Verific	ation	Approval	Approval
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Picklist Print

Thursday, December 16, 2010 11:47:08 AM

Work Order ID: 64768

Parent Item:

D3637-3

Parent Item Name Bracket



Start Date: 12/16/2010

Required Date: 12/21/2010

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A New Issue 07-07-20 JLM

Verified By:EC

IPP Rev:B change to REV.B as per dwg 08-02-11 DD verified by:EC

Component Item ID/ Item Name	Replacement Item II)	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	94.8847	0.134	1.692632	J.5	- - -	

2024-T3 .050 sheet

Location	Loc Oty	Loc Code		,
MAT22	94.8847			TR
111381	11.89	•		(
113189	0.3947			
114968	82.6		114 968	

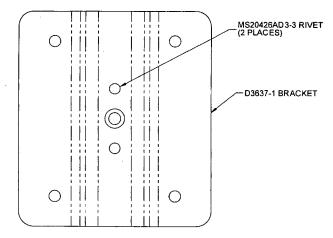
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W/O:			V	ORK ORDER CHANGE	S			: *	•			
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No	•	PAR #:	Fault Ca	tegory:	NCR: Yes	No DQ	A:	Date: _				
Resolution:			Disposit	ion:	QA: N/C Cld	Closed: Date:						
NCR:		V	ORK OR	DER NON-CONFORMA	NCE (NCR)						
		Description of NC		Corrective Action Section		Verific	cation	Approval	Approval			
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DART AEROSPACE LTD	Work Order:	a4768
Description: Bracket	Part Number:	D3637-3
Inspection Dwg: D3637 Rev: B		Page 1 of 1

	FIRST ARTICLE INSPECTION CHECKLIST									
			X First Artic	cle	Proto	otype		•		
	Drawing imension	Tolerance	Actual Dimension	Accept	Reject	Method Inspecti	of on Co	mments		
	4.50	+/-0.030	4.504	8		V 180	2.			
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Meas	ured ๖y:	B	Audited by:	27		Prototyp	e Approval:	N/A		
	Date:	41-61-01	Date:	10/12/17	7		Date:	N/A		
Rev	Date	Change					Revised by	Approved		
Α	08.12.01						KJ/EC	12/		

			•						
W/O:			W	ORK ORDER CHANGE	ES				
DATE STEP		PF	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:							
	Re	esolution:	Dispositi	on:	QA: N/C CI	osed:		Date: _	
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DATE	STEP	Description of NC		Corrective Action Section		Verific		Approval	Approval
	O, E,	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section	on C	Chief Eng	QC Inspector
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MS21059L4 NUT PLATE



D3637-041 BRACKET ASSEMBLY (WAS GENEVA P/N G10602-1)

D3637-041 PARTS:

QTY	P/N	DESCRIPTION
Х	D3637-041	BRACKET ASSEMBLY
1	D3637-1	BRACKET
1	MS21059L4	NUTPLATE
2	MS20426AD3-3	RIVET

D3637-041 NOTES: 1) MATERIAL: N/A 2) FINISH: N/A 3) TOLERANCES: N/A

3) TOLERANDES. N/A
4) UNITS: N/A
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-041" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.27 lbs

SHOP CONY RETURN (10). UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

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work order o. Charles o. Charles

DEGICA	7.0		•	
REV.		DESCRIPTION	BY	DATE
A	NEW ISSUE; REPLACE	LE	07.07.27	
В	FOR D3637-1, 1 15 WAS	LE	07.12.18	

DESIGN	JS_	DART AEROS	SPACE LTD			
DRAWN	1	HAWKESBURY, ONT	FARIO, CANADA			
CHECKED	PH	DRAWING NO.	REV. B			
MFG. APPR.	60	D3637	SHEET 1 OF 3			
APPROVED	1 Not	TITLE	SCALE			
DE APPR.	All I	BRACKET	1:			
DATE 07.1	12.18	COPYRIGHT © 2007 BY DART AEROSPA CE LTD THE DOCUMENT & PRIVATE AND CONFIDENTIAL AND IS SUPPLYED ON THE EXPRESS CONSTROX THAT IT IS				

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W/O:			WO	RK ORDER CHANG	ES				*
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes	s No DQ	A:	Date: _	
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NCR:			WORK ORDE	ER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC	Corrective Action Section B Initial Action Description			Verification Section C			Approval
		Section A	Chief Eng	Action Description Chief Eng	Dat		tion C	Chief Eng	QC Inspector
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D - 3.63 ---0.50 65° (2 PLACES) 0.99 --0.600 -2.000 Ø0.098 0.505 (2 PLACES) С 1.80 C'SINK Ø0.179 X 100° (2 PLACES) Ø0.328 3.60 0.500 3.60 2.590 (TYP) (REF) BEND LINE R0.25 Ø0.191 (TYP) (4 PLACES) <u>D3637-1 BRACKET</u> (WAS GENEVA P/N G10608-1) **D3637-1F FLAT PATTERN** DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. (REF DART SPEC M304S14GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.26 lbs REV. B D3637 MFG. APPR. SHEET 2 OF 3 APPROVED TITLE SCALE **BRACKET** DE APPR COPY RIGHT © 2007 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND COMPONITIAL AND IS SUPPLIED ON THE MEDICAL FOR ANY TO BE USED FOR ANY THE PRIVATE AND TO BE USED FOR ANY THE PRIVATE AND TO BE USED FOR ANY THE PRIVATE AND THE PRIVATE A DATE 07.12.18 8 7 5 4 3 2

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Dart Aerospace Ltd WORK ORDER CHANGES W/O: Approval **Approval** PROCEDURE CHANGE Ву Qty Chief Eng / Prod Mgr DATE **STFP** Date QC Inspector Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ____ Date: ____/ Resolution: _____ Disposition: ____ QA: N/C Closed: ____ Date: ____ **WORK ORDER NON-CONFORMANCE (NCR)** NCR: Corrective Action Section B Verification **Description of NC Approval Approval** STEP DATE Sign & **Action Description** Initial Section A Section C Chief Eng QC Inspector Date Chief Eng Chief Eng

Chief Eng Chief Eng Date

3 alo 44748 65° (2 PLACES) (REF) R0.16 (REF) - 1.30 -- 4,500 2.04 -0.955 R0.25 (TYP) Ø0.266 (4 PLACES) 117 1.25 BEND ON 0.16 RAD Ø0.098 THRU C C'SINK Ø 0.179 X 100° С (8 PLACES) GRAIN DIRECTION 0.344 4.50 (REF) | 2.000 4.50 (TYP) .686 4.50 540 1,734 R0.25 (TYP) D3637-3 BRACKET (WAS GENEVA P/N G10609-1) **D3637-3F FLAT PATTERN** D3637-3 NOTES:
1) MATERIAL: 2024-T3 ALUMINUM 0.050 THICK PER QQ-A-250/4 OR AMS 4037
(REF DART SPEC M2024T3S.050)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-3" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.32 lbs DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. B D3637 MFG. APPR. SHEET 3 OF 3 TITLE APPROVED SCALE **BRACKET** DE APPR. 2:3 COPYRIGHT © 2007 BY DART AEROSPACE LTD
THE DOCLMENT IS PRIVATE AND COMPIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION OF THE DESCRIPTION OF THE PERSON OF DATE 07.12.18 8

Dart Aerospace

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W/O:	o: WORK ORDER CHANGES				GES	ES				
DATE	STEP	PRO	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
Part No	:	PAR #:	Fault Cat	egory:	NCI	R: Yes	No DQ	A :	Date:	
	R	esolution:	Dispositi	on:	QA	N/C CI	osed:		Date: _	
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DATE	STEP	Description of NC	Corrective Action Section B			0:	Verification		Approval	
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